

Friday, 10/10/2008 8:35:15 AM
Julie Lecocq

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	D205-596-103
Job Number :	42528 39550	Part Number :	REWORK11
Estimate Number :	10804	Drawing Number :	NCR08-091
P.O. Number :		Project Number :	
This Issue :	10/10/2008 S.O. No. :	Drawing Revision :	
Prsht Rev. :	NC	Material :	
First Issue :	/ / Type :	Due Date :	16/10/2008
Previous Run :	00015	Qty:	1 Um: Each
Written By :			
Checked & Approved By :	JLO 08.10.10		
Comment :			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D205596103	Crosstube Aft Extended
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Comment: Qty: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Crosstube Aft Extended
B39550

2.0	QC	QUALITY CONTROL
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Comment: QUALITY CONTROL

See NCR08-091
Damage on the tube was found at 2' up from the cuff, on the aft, right hand side, 2" long, by 0.001" deep into the aluminum.

3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1
- Wrap the left hand side of the tube to protect from any damage, starting at the right side support.
- Blend out the affected area.
- Sand the paint around the affected area smooth.

ALM 8-10-2008

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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ALM 8-10-20



Comment: HAND FINISHING RESOURCE #1—
Alodine the affected area as per QSI005

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SOS/10/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

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Drawing Name: D205-596-103

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Part Number: REWORK11

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Scuff the RH side of the tube, and touch up with primer & re-paint as per QSI 005.

25 08-10-29

7.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

MF 08 10 30 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Re-package tube with the original documentation.

Return to stock with the original batch #.

Location: _____

JW 08/10/30

JS 08/10/30 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*** Add a copy of this w/o to the original w/o, and to NCR08-091.***

08/10/31 JF

Job Completion



MF 08-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST:

Qty	Part Number	Description
X	D205-596-103	CROSSTUBE ASSEMBLY, HI-HI AFT
1	D6008-180	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

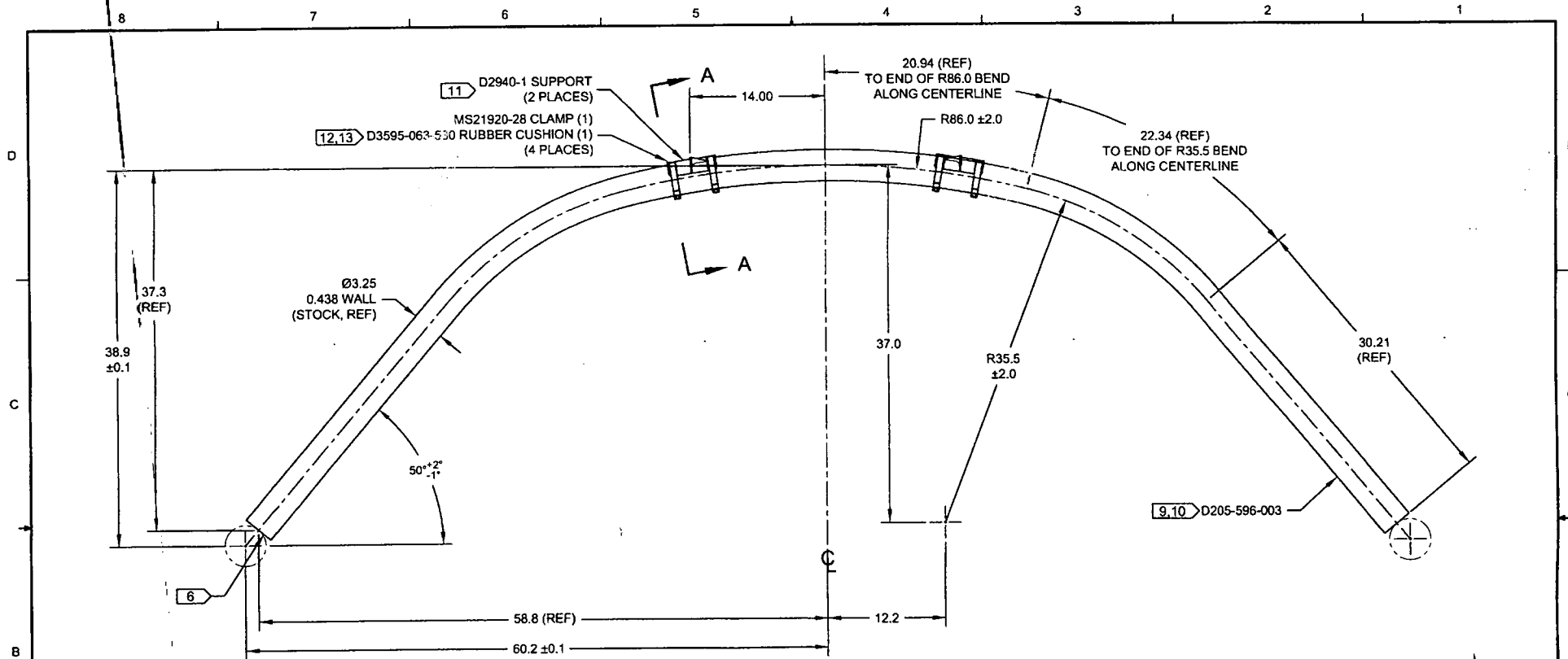
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 146.98 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH
VIBRATING STYLUS
- 7) WEIGHT: 55 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER
MS21920-XX CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF
1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

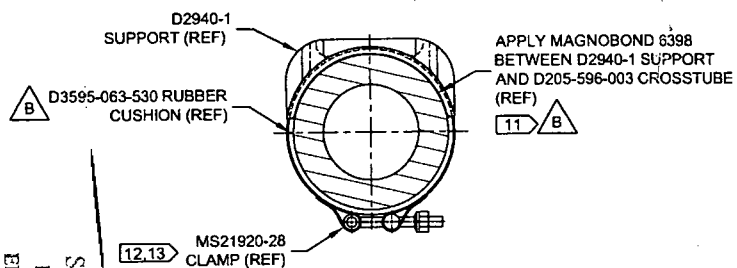
07.01.16 MP

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WORK ORDER
NO 42528

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D205-596-103	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
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D205-596-103 CROSSTUBE ASSEMBLY, HI-HI AFT



SECTION A-A
SCALE 2:5

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D205-596-103	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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